

Work Order ID 161929

161929

Page 1

Tuesday, May 23, 2017 11:02:57 AM

Item ID: D4753-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 6/8/2017 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 6/15/2017 Req'd Qty: 24.00 *24* Customer:

Reference:

Approvals: Process Plan: 21 Date: MAY 24 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4753	A

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.64
 FLOW CNC Waterjet 1-Cut as per Dwg D4753
 Dwg Rev: A
 Prog Rev: A
 ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT
 UPON INSTALLATION**
 3- Deburr if necessary

(24) SC 17/06/08
 or 17/06/08

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.24
 Quality Control

(24) SC 17/06/08
 or 17/06/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 2

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120

0.37

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.97

B.P. 17-06-12

24

φ

DAS
08
9-89

HAAS CNC vertical machine #1

Machine as per Folio FB163 and Dwg D3506

FOLIO REV: AADWG REV: A***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT
UPON INSTALLATION**

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.24

B.P. 17-06-12

24

φ

DAS
08
9-89

Quality Control

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.48

24

φ

DAS
14
9-89

Quality Control

17/06/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/8/2017 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 6/15/2017 **Req'd Qty:** 24.00

24

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

BE13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>10/929</u> Part No. <u>DY753-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☒</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																															
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.24				<u>24</u> 23			DAS 38 9-89 JUN 20 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : LG001	0.00 0.24				<u>24</u> 23			DAS 6 9-89 JUN 21 2017
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 2.40							17/6/27 DAS 21 9-89 JUN 22 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

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161929

Parent Item: D4753-1

D4753-1

Parent Item Name: Doubler

Start Date: 6/8/2017

Required Date: 6/15/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	71.3970	0.0138	0.3312			

M6061T6S 125

6061-T6 .125 Sheet

**

SC 17/06/06
17/06/08

Location

Loc Qty

Loc Code

MAT019

67

m136896

35

m137515

32

MAT020

4.397

m136327

4.397

0,4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

8 7 6 5 4 3 2 1

D

C

B

Ø0.128 THRU
CSK Ø0.228X100°
2PL

Ø3.54

Ø0.758

0.100 X 45°
4 PL

0.126

0.750

1.500

2.000

1.000

0.500

D4753-1 DOUBLER

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 161929 MJS
170524

RELEASE
R 2013-03-25

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC.		REV. A	
DRAWN	AP	KENT, WA		SHEET 1 OF 1	
CHECKED	AP	DRAWING NO.	D4753		
MFG. APPR.	AP	TITLE	DOUBLER		
APPROVED	AP	DATE	13.02.13		
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8 7 6 5 4 3 2 1

